


Date: Tuesday, 20/05/2008 3:54:03 PM
 User: Jean-Luc Menard

Process Sheet

OK

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SLEEVE
Job Number	: 39350		
Estimate Number	: 13330		
P.O. Number	:	Part Number	: D37861
This Issue	: 20/05/2008 S.O. No. :	Drawing Number	: PROTO Rev A # 01.05.20
Prsht Rev.	: NC	Project Number	: IA0004
First Issue	: 20/05/2008 Type : R&D MACHINED PARTS	Drawing Revision	: PROTO
Previous Run	:	Material	:
Written By	: 	Due Date	: 27/05/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A 08-05-20 new issue verified by:JLM		

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #	Machine Or Operation:	Description :
--------	-----------------------	---------------

1.0	M6061T6T1000W065	6061T6 TUBE
-----	------------------	-------------



Comment: Qty.: 0.1750 f(s)/Unit Total : 0.1750 f(s)

6061T6 TUBE

batch: 107930

RD 08/05/23

2.0	DOOSAN LATHE	DOOSAN LATHE
-----	--------------	--------------



Comment: DOOSAN LATHE

1- Turn as per Folio FA747 Rev.  & Dwg D3786 Rev. 

2-Deburr per dwg D3786

RD 08/05/23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RD 08/05/23

(5)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

RD 08.05.23

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RD 08/05/23

(5)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLEEVE

Job Number: 39350

Part Number: D37861

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



08.05.27 (5)



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



08.05.29



Comment: PACKAGING RESOURCE #1

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.05.29 Prototype

Job Completion



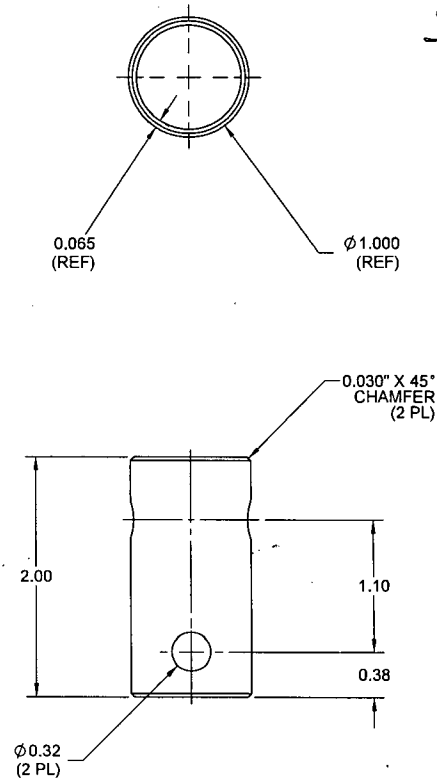
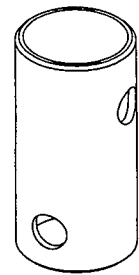
Change to w/o 20/06

U 08.06.10

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

UP 08.05.06

Doosan
Folio 747



72

218

D3786-1 SLEEVE

- NOTES:
- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM TUBING 1.00" X 0.065" WALL (REF. DART SPEC. M6061T6T1.000W.065)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.03 lbs

REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3786	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SLEEVE	1:1
DATE	08.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order:	39350
Description: D377-6 D3786-1 Sleeve		Part Number:	D3786-1
Inspection Dwg:	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by: <i>PO</i>	Audited by: <i>[Signature]</i>	Prototype Approval: <i>PO</i>
Date: <i>08/05/23</i>	Date: <i>08/05/23</i>	Date: <i>08.05.26</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Receiving Report

Date: 8/5/6

Batch No: M107950

Supplier: MARMON

Dart P/O: 6269

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ 6/20/08 N/A ☐
 Work Order ☐ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date 08/05/08
 Received/Costing RCP 7822
 Initial CR

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

RECEIVED MAY 09 2008

Energy Surcharge

12.20

ORIGINAL INVOICE / FACTURE ORIGINALE

G.S.T. /HST	18.02
T.P.S.	.00



PAYMENT OF THIS INVOICE IS DUE BY
 LE RÈGLEMENT DE CETTE FACTURE EST EXIGIBLE AU PLUS TARD LE

06/04/2008

378.38

FEB 18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 14506414357

P.02/03

18/2008 From: MARMON/KEYSTONE
 /K OR:
 C.P.O.:
 C PART:

INIT.:

To:

OR. REF:
 SLSPRS:

KAISER ALUMINUM FABRICATED PRODUCTS

Beck

CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

KAISER ALUMINUM
 FABRICATED PRODUCTS
 6573 W. WILLIS ROAD
 CHANDLER, AZ 85226

CUSTOMER PO NUMBER: 80-33603		CUSTOMER PART NUMBER: AT11.065/734		PRODUCT DESCRIPTION: Seamless Tube	
KAISER ORDER NUMBER: 200438	LINE ITEM: 005	SHIP DATE: 11/27/2007	KAISER LOT NUMBER: F00000606	ALLOY: 6061	TEMPER: T6
WEIGHT SHIPPED: 331.000 LB	QUANTITY: 123.000 PCS	SA NUMBER: 200274	DIM/DIA/THICKS: 12.000 FT	WIDTH:	LENGTH:
SHIP TO: MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA			SOLD TO: MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA		

Actual Physical Properties

REFERENCE	DASH#	SAMPLES	UTS(KSI)	YTS(KSI)	ELONG%	HARDNESS	CONTIGS	REMB
F00000606	0001	1	46.5	42.6	17.0	N/A	N/A	N/A

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Sr	Sa	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
R22452	.62	.39	.22	.05	.92	.06	.03	.02	.00	.01	.00	.00	.00

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms conditions of sale. Test reports are on file subject to examination.

Wilfredo A. de la Cruz, Sr. Metallurgical Engineer

Plant Serial: 00000266

Wilfredo A. de la Cruz

Kaiser Order Number: 200438

Page 1 of 2

Line Item: 005

Q.C. REVIEWED

FEB 06 2008 13:10

AT 1.065 734

PAGE.02

DART

18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 1450041

2/2008 From: MARMON/KEYSTONE

INIT.:

To:

OR.REF:

SLSPRS:

OR:

P.O.:

PART:

KAISER
ALUMINUM
FABRICATED PRODUCTS

KAISER ALUMINUM
FABRICATED PRODUCTS
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

Applicable Requirements:

Description: OD: 1.000"; Wall: 0.065"; Round @
AMS-4082N ASTM-B210-04 NW-T-700/6P
WE TAKE EXCEPTION TO PARA. 5.2.1. PER AMS 4082N, WAS NOT OILED.
THE FOLLOWING SPECIFICATION HAVE BEEN MADE INACTIVE OR
CANCELLED: MIL-T-7081, NW-T-700F/GEN, NW-T-700/2E, NW-T-700/3F.
NW-T-700/4F, NW-T-700/5E, NW-T-700/6F, NW-T-700/7H.
COMPLIES TO THE REQUIREMENTS OF DIN EN 10204
COMPLIES TO DIN EN 10204 JAN 2005

Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms conditions of sale. Test reports are on file subject to examination.

Wilfredo A. de la Cruz, Sr. Metallurgical Engineer

Wilfredo A. de la Cruz

Page 2 of 2

Plant Serial: 00000264

Kaiser Order Number: 200438

Line Item: 005

FEB 06 2008 13:11

PAGE.03

** TOTAL PAGE.03 **

DART